

Work Order ID 63163

Friday, October 22, 2010 8:08:10 AM



Page 1

Item ID: D350-689-019

Accept



Setup Start



Revision ID:

Stop



Item Name: Control Guard

Start Date: 10/21/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/28/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

10-10-22

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI 9493	A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-689-019 CHG001

8/10/25

10-10-29

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

10/10/25

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

8/10/25

76

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63163

Friday, October 22, 2010 8:08:10 AM



Page 2

Item ID: D350-689-019

Accept



Setup Start



Revision ID:

Stop



Item Name: Control Guard

Start Date: 10/21/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/28/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-689-019 Location: _____ PPP Rev: <u>0.07-1</u>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/11/10

PL 10-10-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, October 22, 2010 8:08:14 AM

Page 1

Work Order ID: 63163

Parent Item: D350-689-019

Parent Item Name: Control Guard



Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.04.23 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-12A 		Purchased	No			110	Each	306.0000	1	1		10/10/29	
Bolt													

Location	Loc Qty	Loc Code
ST357	306	
112314	106	
115371	40	
115422	160	

AN4-20A 		Purchased	No			110	Each	467.0000	1	1		10/10/29	
Bolt													

Location	Loc Qty	Loc Code
ST359	467	
104016	267	
115936	200	

D3084-3 		Manufactured	No			110	Each	1.0000	1	1		10/10/29	
Strut													

Location	Loc Qty	Loc Code
ST271	1	
62390	1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, October 22, 2010 8:08:14 AM

Page 2

Work Order ID: 63163

Parent Item: D350-689-019

Parent Item Name: Control Guard

Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 1.00

Required Qty: 1.00

MS21042-4

Purchased

No

110

Each

114.0000

2

2



USE MS21042L4



MISS 89 10/21/2010

Location

Loc Qty

Loc Code

ST299

114

100743

9

5389

80

5461

3

6844

19

9229

3

NAS1149D0416J

Purchased

No

110

Each

429.0000

8

8



Washer



10/21/2010

Location

Loc Qty

Loc Code

ST298

429

110153

2

114103

50

114884

200

115107

140

13910

37

NAS43DD4-46N

Purchased

No

110

Each

25.0000

2



SPACER



10/21/2010

Location

Loc Qty

Loc Code

ST279

25

111886

25

Friday, October 22, 2010 8:08:14 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-689 REV. A

REF TCCA STC: SH02-33

REF FAA STC: SR01620NY

REF EASA STC: EASA.IM.R.S.01453

REF BRAZILIAN STC: 2005S03-09

REFERENCE ONLY

PURPOSE:

TO PROVIDE AN OPTIONAL CONTROL GUARD KIT TO BE INSTALLED ON THE D350-689-011/-021 DUAL HIGH BACK SEAT INSTALLATIONS.

CHANGE:

OPTIONAL D350-689-019 CONTROL GUARD KIT ADDED AS DETAILED BELOW. WHEN INSTALLING THE AN4 BOLTS IN THE DART SEAT, DRILL QTY (2) Ø0.257" HOLES PER INSTRUCTIONS (SEE SHEET 2 DETAIL A OF THIS SERVICE INSTRUCTION FOR REFERENCE).

Qty -011	Qty -013	Qty -019	Qty -021	Qty -023	Qty -041	Qty -043	Part Number	Description
X							D350-689-011	DUAL HIGH BACK SEAT INSTALLATION, LH
1	X						D350-689-013	FLOOR PROVISIONS KIT
		X					D350-689-019	CONTROL GUARD KIT
			X				D350-689-021	DUAL HIGH BACK SEAT INSTALLATION, LH (REF DSI 9419)
			1	X			D350-689-023	ENERGY ATTENUATING FLOOR PROVISION KIT (REF DSI 9419)
1					X		D350-689-041	DUAL HIGH BACK SEAT ASSEMBLY
			1			X	D350-689-043	DUAL HIGH BACK SEAT ASSEMBLY (REF DSI 9419)
		1					D3084-3	STRUT
		2					NAS43DD4-46N	SPACER
		1					AN4-12A	BOLT
		1					AN4-20A	BOLT
		2					MS21042-4	NUT (OR MS24042L4)
		8					NAS1149D0416J	WASHER

INSTRUCTIONS:

1. LOCATE LOWER HOLE (SEE FIGURE 1 SHEET 2) AND DRILL Ø0.257" HOLE.
 2. USING STRUT P/N D3084-3 AS TEMPLATE, TEMPORARILY FASTEN TO LOWER HOLE, LOCATE UPPER HOLE ON CENTER LINE OF TUBE. REF FIGURE 1.
 3. DRILL Ø0.257" HOLE.
 4. REMOVE BURRS AND SHARP EDGES ON BOTH HOLES AND TOUCH UP PER ICA-D350-689 CHAPTER 5.2 SECTION 8.
 5. INSTALL STRUT USING HARDWARE SHOWN. TORQUE FASTENERS TO 50-70 in-lbs.
- LONGER AN4 BOLTS ARE ACCEPTABLE TO ENSURE A MINIMUM OF 1.5-2 THREADS IN SAFETY.

WEIGHT AND BALANCE:

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-689-019 CONTROL GUARD KIT. (Seat's Fwd position)	0.5 lb 0.23 kg	-9.0 in -0.23 m	- 4.5 in-lb -0.05 m-kg	60.7 in 1.54 m	30 in-lb 0.35 m-kg
D350-689-019 CONTROL GUARD KIT. (Seat's Aft position)	0.5 lb 0.23 kg	-9.0 in -0.23 m	- 4.5 in-lb -0.05 m-kg	64.7 in 1.64 m	32 in-lb 0.38 m-kg

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-Q-01





APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 10.04.01

CERT. NO.: SH02-33

ISSUE NO.: 1

A	NEW ISSUE.	JPH	10.04.01
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9493	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		INSTALLATION OF CONTROL GUARD	NTS
DATE	10.04.01	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	